

Date: Thursday, 3/16/2006 10:38:28 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER RING
Job Number	: 26281		
Estimate Number	: 12176		
P.O. Number	: N/A	Part Number	: D34765
This Issue	: 3/16/2006 S.O. No. : N/A	Drawing Number	: D3476 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 3/31/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>06.03.16</u>		
Comment	: Est Rev:A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: Issue P/O: \_\_\_\_\_  
 E-mail or Ship DXF file to vendor  
 Laser cut flat pattern as per Dwg D3476  
 Possible supplier: Ind. Laser  
 Material release note is required.

2.0	D34765F	spacer ring
-----	---------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 FLANGE PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1  
 Receive & inspect For Transit Damage  
 Ensure material certification is attached

*Fabricate* *CNC cell*  
*M# 7106*

*06.03.24*  
*06.03.17*

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

*06.03.24*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.  
 2-Roll as per Dwg D3476

*06.03.24*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/04/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 3/16/2006 10:38:28 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER RING

Job Number: 26281

Part Number: D34765

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.03.29

①

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: \_\_\_\_\_

Electro Chemically Polish weldment as per Dwg D3476

Ensure Certificate of Conformity is attached

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

06.03.29

Job Completion



Inspection Level 21

06.03.30

06.04.29

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06.03.17		Cancel steps 7, 8, 9				<i>[Signature]</i> 06.03.17	<i>[Signature]</i> 06.03.17	
06/03/30		ADD inspection level 21 <i>[Signature]</i> 06/03/30	<i>[Signature]</i>	06.04.03				

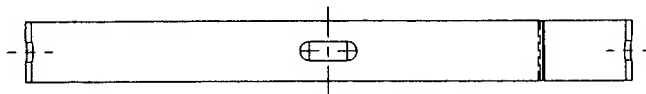
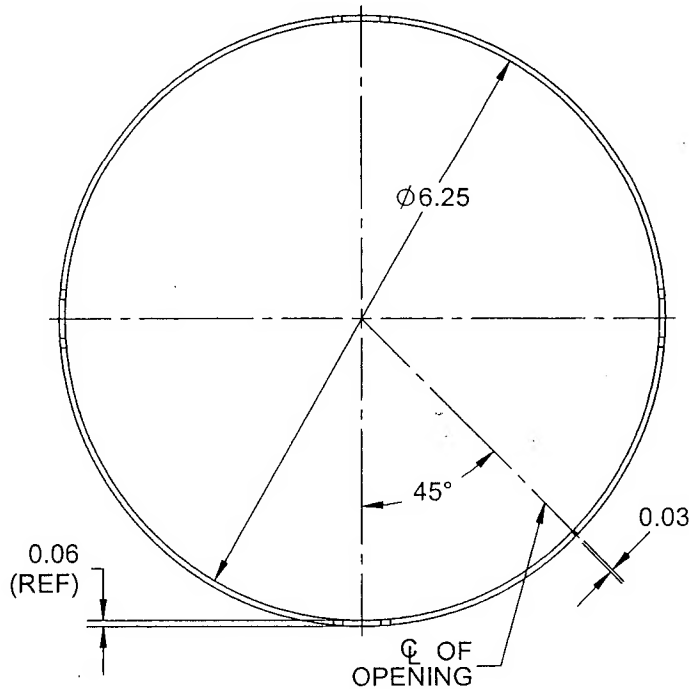
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

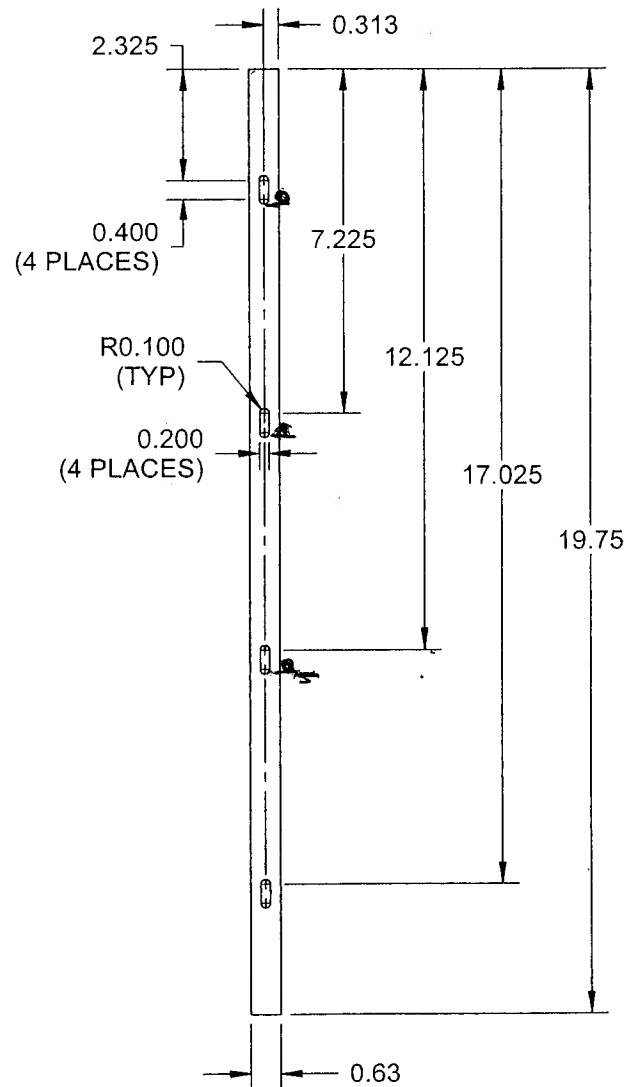
**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3476	REV. A SHEET 6 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



**D3476-5 SPACER-RING**



**D3476-5F SPACER-RING  
FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED)  
2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

M1106